



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
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D117-1044-111
Job Sheet 183900



Part No: D117-1044-111

Job Qty: 1 ea

Part Name: H145 Quick Release Heli-Utility-Basket™ Crosstube Adapter



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/28/18

Job Tracking No:

Due Date: 10/19/18

Created By: Marie Lajeunesse

Type: SOLD

5902

Description:

Note: IIN-D117-1044 REV B IPP REV: A 18.01.17 NEW ISSUE DD VERF: JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/19/18	10/19/18	0.00	0.00	Start Up Stores/Pkg-1	6	OCT 12 2018
110	Packaging	1 pcs	10/19/18	10/19/18	0.00	0.00	Packaging1-1	DAS 6-89	OCT 12 2018
130	QC	1 pcs	10/19/18	10/19/18	0.00	0.00	QC4	69 9-89	NOV 13 2018
135	DC	1 pcs	10/19/18	10/19/18	0.00	0.00	DC	69 9-89	NOV 14 2018
140	Packaging	1 pcs	10/19/18	10/19/18	0.00	0.00	Packaging3-1	DAS 69 9-89	NOV 13 2018
150	QC21-FG	1 Ea	10/19/18	10/19/18	0.00	0.00	QC21	69 9-89	NOV 14 2018

Part Op 135 - Photocopy bluefile & type labels per PPP D117-1044-111 CHG 001
Descriptions: 140 - Identify and pack for shipping as per PPP D117-1044-111 Location: _____ PPP Rev: 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5069-1	Hardpoint Adapter 136	4 Ea (4 ea)	90-Start up Operation	5059148
DIN65270-12D 559	Nut	4 pcs (4 ea)	90-Start up Operation	FM138533x1 FM138536x3
EN2367-23025 561	Cotter Pin	4 pcs (4 ea)	90-Start up Operation	FM138533-40
D5612-041	Adapter Wrench 17	1 Ea (1 ea)	90-Start up Operation	5059212

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5069-1	4	8	0
	D5612-041	1	7	0
	DIN65270-12D	4	8	0
	EN2367-23025	4	7	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation				Disposition																			
Dart Aerospace Ltd. 1270 Aberdeen Street Peterborough, ON K6A 1K7 CANADA TEL.: 1 613 522-6200 Email: sales@dartaero.com www.dartaero.com Container No: S117714 Part: D117 - 1044 - 111 Job No: 183900 Serial No/Batch: S117714 Revision: B Inspector: _____ Exp Date: _____ Instructions: FAA STC SR02578SE 17/12/13, EASA STC 100				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																			
				FAULT CATEGORY																			
				<table style="width:100%; border: none;"> <tr> <td style="width:33%; vertical-align: top;"> ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter </td> <td style="width:33%; vertical-align: top;"> ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes </td> <td style="width:33%; vertical-align: top;"> ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center </td> </tr> <tr> <td style="vertical-align: top;"> ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence </td> </tr> </table>				☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence												
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4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the Heli-Utility-Basket™ kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D117-1044-011/-012 (Heli-Utility-Basket™, LH/RH Install)	134 lb 60.8 kg	+/-40.5 in +/-1.03 m	+/-5427 in-lb +/-62.6 m-kg	167 in 4.24 m	22378 in-lb 257.8 m-kg
D117-1044-111 (Crosstube Adapter Kit, Install)	3.5 lb 1.6 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	165.5 in 4.20 m	579 in-lb 6.7 m-kg
D117-1044-113/-114 (QR Basket Mounting Provision Kit, LH/RH Install, includes D117-1044- 111 Crosstube Adapter kit above)	56 lb 25.4 kg	+/-14.7 in +/-0.37 m	+/-823 in-lb +/-9.4 m-kg	167 in 4.24 m	9352 in-lb 107.7 m-kg

5.0 PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -111	Qty -113	Qty -114	Part Number	Description
X						D117-1044-011	HELI-UTILITY-BASKET, LH
	X					D117-1044-012	HELI-UTILITY-BASKET, RH
		X				D117-1044-013	PROP ARM KIT (OPTIONAL)
			X	1	1	D117-1044-111	CROSSTUBE ADAPTER KIT
1				X		D117-1044-113	QR BASKET MOUNTING PROVISION KIT, LH
	1				X	D117-1044-114	QR BASKET MOUNTING PROVISION KIT, RH
		1*				D2332-041	PROP ASSEMBLY (OPTIONAL)
1						D5067-011	BASKET ASSEMBLY, HEAVY DUTY, LH
	1					D5067-012	BASKET ASSEMBLY, HEAVY DUTY, RH
			4			D5069-1	HARDPOINT ADAPTER
1	1					D5203-043	STRUT ASSEMBLY
				1		D5549-011	FWD BEAM ASSEMBLY, LH
					1	D5549-012	FWD BEAM ASSEMBLY, RH
				1		D5549-013	AFT BEAM ASSEMBLY, LH
					1	D5549-014	AFT BEAM ASSEMBLY, RH
			1			D5612-041	ADAPTER WRENCH
			4			DIN65270-12D	NUT
			4			EN2367-23025	PIN, COTTER
		2*				MS24665-300	COTTER PIN

* D2332-041 PROP ASSEMBLY & HARDWARE (OPTIONAL) TO REPLACE D3969-3 GAS SPRING

